The embodiments of the invention in which an exclusive property or privilege is claimed are defined as follows:

1. A tray evaluating system comprising:

a tray destacking device operable to receive a stack of trays and to destack individual trays from the stack and to discharge the individual trays; and

a tray scanning device operable to receive the individual trays from said tray destacking device and to scan the trays to determine the dimensions and orientation of the trays, said tray evaluating system being operable to determine if the scanned trays are in an acceptable condition for use.

2. The tray evaluating system of claim 1, wherein said tray scanning device is operable to determine if articles or debris are within the individual trays.

3. The tray evaluating system of claim 1 including a tray rotating device operable to rotate at least some of the trays to a desired orientation in response to said tray scanning device.

4. The tray evaluating system of claim 1 including a tray discharge operable to discharge trays that are not in an acceptable condition.

5. The tray evaluating system of claim 1 including a tray stacking device operable to stack acceptable trays to a desired height or number of trays.

6. The tray evaluating system of claim 5 including a tray palletizer operable to arrange stacks of acceptable trays on pallets for shipment of the trays.

7. A container handling system for loading/unloading trays on a cart, said container handling system comprising:

a transfer unit positioned at a conveyor; and

a container moving device operable to move containers at least one of (a) from said transfer unit to an appropriate shelf of a cart adjacent to said transfer unit, and (b) from an appropriate shelf of a cart adjacent to said transfer unit onto said transfer unit, said transfer unit being operable to at least one of (a) receive containers from the conveyor and transfer the

containers to said container moving device and (b) receive containers from said container moving device and transfer the containers to the conveyor.

8. The container handling system of claim 7, wherein said container moving device is operable to move containers from said transfer unit to an appropriate shelf of a cart adjacent to said transfer unit.

9. The container handling system of claim 8, wherein said transfer unit receives containers at an induct and transfers the containers to a loading portion of said transfer unit, said container moving device moving containers from said loading portion to the appropriate shelf.

10. The container handling system of claim 9, wherein said transfer unit is operable to singularly position a container at an appropriate location on said loading portion, said container moving device being operable to move each singularly positioned container to the appropriate shelf.

11. The container handling system of claim 9, wherein said transfer unit is operable to position multiple containers on said loading portion, said tray moving device being operable to move multiple containers as a batch from said loading portion to the appropriate shelf.

12. The container handling system of claim 7, wherein said container moving device is operable to move containers from an appropriate shelf of a cart adjacent to said transfer unit onto a loading portion of said transfer unit.

13. The container handling system of claim 12, wherein said transfer unit is operable to move containers from said loading portion to a discharge of said transfer unit.

14. The container handling system of claim 7, wherein the shelves of the cart are adjustable shelves, whereby when one shelf is filled with containers, the filled shelf is moved from said container moving device and an empty shelf is positioned at said container moving device.

15. A cart management system for managing carts of trays at a loading/unloading area of a material handling facility, said cart management system comprising:

a first transport conveyor operable to receive carts at an induct and to transport carts of trays along said first transport conveyor;

a second transport conveyor operable to transport carts therealong;

a plurality of buffers positioned between said first and second transport conveyors, said first transport conveyor operable to selectively transfer carts onto said buffers, said buffers being operable to selectively discharge carts onto said second transport conveyor; and

at least one discharge positioned along said second transport conveyor.

16. The cart management system of claim 15, wherein said first and second transport conveyors comprise at least one drive member operable to move carts therealong.

17. The cart management system of claim 15, wherein said first transport conveyor receives carts from an induct station and said second transport conveyor selectively discharges carts to at least one trailer loading device.

18. The cart management system of claim 15, wherein said first transport conveyor receives carts from at least one trailer unloading device and said second transport conveyor discharges carts to a discharge area.

19. The cart management system of claim 15, wherein said first transport conveyor is operable to move carts in opposite directions relative to said buffers to selectively arrange carts on the appropriate buffers and in the appropriate order.

20. The cart management system of claim 15, wherein said buffers are configured to receive stacks of carts, said cart management system being operable to stack carts at said buffers.

21. The cart management system of claim 20, wherein said cart management system is operable to unstack carts from said buffers and to selectively discharge the unstacked carts to said second transport conveyor.

22. The cart management system of claim 20, wherein said second transport conveyor is operable to transport the stacked carts to said at least one discharge to discharge the stacked carts.

23. The cart management system of claim 15, wherein said first transport conveyor includes a transfer unit at each of said buffers, said transfer unit being selectively operable to transfer carts from said first transport conveyor to the respective buffer.

24. The cart management system of claim 23, wherein said transfer unit is selectively operable to raise upwardly to lift the cart and to transfer the cart to the respective buffer.

25. The cart management system of claim 23, wherein said transfer units are operable to convey carts along said transfer units in a direction generally along said first transport conveyor.

26. The cart management system of claim 25, wherein each of said transfer units is selectively operable to rotate to change the direction of conveyance of said transfer unit to selectively transfer the cart from said first transport conveyor to the respective buffer.